

Date: Monday, 27/11/2006 11:47:40 AM
User: Linda Lacelle

Process Sheet

Customer : CC-DAR01 Dart Aerospace Ltd.	Drawing Name : D2582
Job Number : 29706	
Estimate Number : 10804	
P.O. Number :	Part Number : D2582
This Issue : 27/11/2006 S.O. No. :	Drawing Number : RTN 539
Prsht Rev. : NC	Project Number :
F rst Issue : / / Type : SMALL /MED FAB	Drawing Revision :
Previous Run : 00015	Material :
Written By :	Due Date : 04/12/2006 Qty: 1 Um: Each
Checked & Approved By :	
Comment :	

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
1.0	QC5	INSPECT WORK TO CURRENT STEP



Comment: INSPECT RTN 539



06/11/27 (1)

2.0	D2582	Hi-Skid Step Leg Ass'y
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Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)
Hi-Skid Step Leg Ass'y
ORIGINAL B/N 27756

3.0	PACKAGING 1	PACKAGING RESOURCE #1
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Comment: PACKAGING RESOURCE #1
ID & STK
USING NEW B/N

PV 4/11/28 (1) Pst E.

4.0	QC21	FINAL INSPECTION/W/O RELEASE
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Comment: FINAL INSPECTION/W/O RELEASE

Job Completion



u 8011.29

Date: Wednesday, 6/28/2006 4:18:25 PM
 User: Kim Johnston

Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services	Drawing Name	: HI-STEP LEG ASSEMBLY
Job Number	: 27756		
Estimate Number	: 10355		
P.O. Number	: N/A	Part Number	: D2582
This Issue	: 6/28/2006	S.O. No.	: N/A
Prsht Rev.	: NC	Drawing Number	: D2582 REV A
First Issue	: N/A	Project Number	: N/A
Previous Run	: 25395	Drawing Revision	: A
	Type : SMALL /MED FAB	Material	: N/A
Written By	: <u>See Comment Below</u>	Due Date	: 7/12/2006
Checked & Approved By	: <u>06 06 29</u>	Qty:	20
Comment	: Est Rev: F Removed Manufacturing 05-11-07 JLM	Um:	Each

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	27756A	SPACER
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Comment: Sub-Component SPACER

2.0	27756B	STEP LEG
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Comment: Sub-Component STEP LEG

3.0	27756C	STEP SPACER
-----	--------	-------------



Comment: Sub-Component STEP SPACER

4.0	27756D	STEP SPACER
-----	--------	-------------



Comment: Sub-Component STEP SPACER

5.0	MS20470AD44	Rivet, Universal Head
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Comment: Qty.: 22.0000 Each(s)/Unit Total : 440.0000 Each(s)

Pick:

Qty Part Number Description Batch

22 MS20470AD4-4

Rivet

~~118729~~

M19073

53

255

242

M18729

M100993

CH

6.0	MS20470AD45	Rivet, Universal Head
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Comment: Qty.: 4.0000 Each(s)/Unit Total : 80.0000 Each(s)

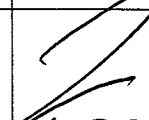
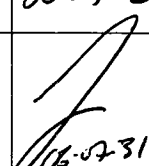
Pick:

Qty Part Number Description Batch

4 MS20470AD4-5

Rivet

M18461

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Mfg / Design Mgr	Approval QC Inspector	
06-07-31	6.1	Need D2280 picked to complete the Ass'y. Add to estimate permanent change.					 06-07-31	
		Pick 2x D2280 per Ass'y B27756A	SAD	06-07-31				
06-07-31	8.0	Stock { 2x D2379 spacer B27756 I.D. } 4x D2278 B27756 leg. in G.A. As overstock.	SAD	06-07-31			 06-07-31	

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Design Mgr	Approval QC Inspector
			Initial Design Mgr	Action Description Design Mgr	Sign & Date			
06-07-31	7.0	Upon drilling and replacing rivets in the step ass'y, holes were ovalized to over tol. R.C. drill bit wander. in on rivet head, and not being centered.	UP 06-08-06 per Q51042	destroy: replace: 2x D2280 B27756A 1x D2379 B27756 2x D2278 B27756 3 Ass'y Incomplete. No more D2322.	SAD 06-07-31	06-07-31	UP 06-08-09 per Q51042	06-07-31

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes (No) DQA: Date: 06/08/10

NOTE: Date & initial all entries

QA: N/C Closed: _____ Date: _____

Date: Wednesday, 6/28/2006 4:18:25 PM
User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: HI-STEP LEG ASSEMBLY

Job Number: 27756

Part Number: D2582

Job Number:



Seq. #:

Machine Or Operation:

Description :

7.0

SMALL FAB 1

SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1

Assemble as per Dwg D2582 and

SAD

06:07:30

17

8.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

9.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: WA26

L.E. 06.8.1

17

10.0

DC

DOCUMENT CONTROL



Comment: DOCUMENT CONTROL

Inspection Level 21

06/08/10

17

Job Completion



C206108103

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Mfg / Design Mgr	Approval QC Inspector

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Design Mgr	Approval QC Inspector
			Initial Design Mgr	Action Description Design Mgr	Sign & Date			

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

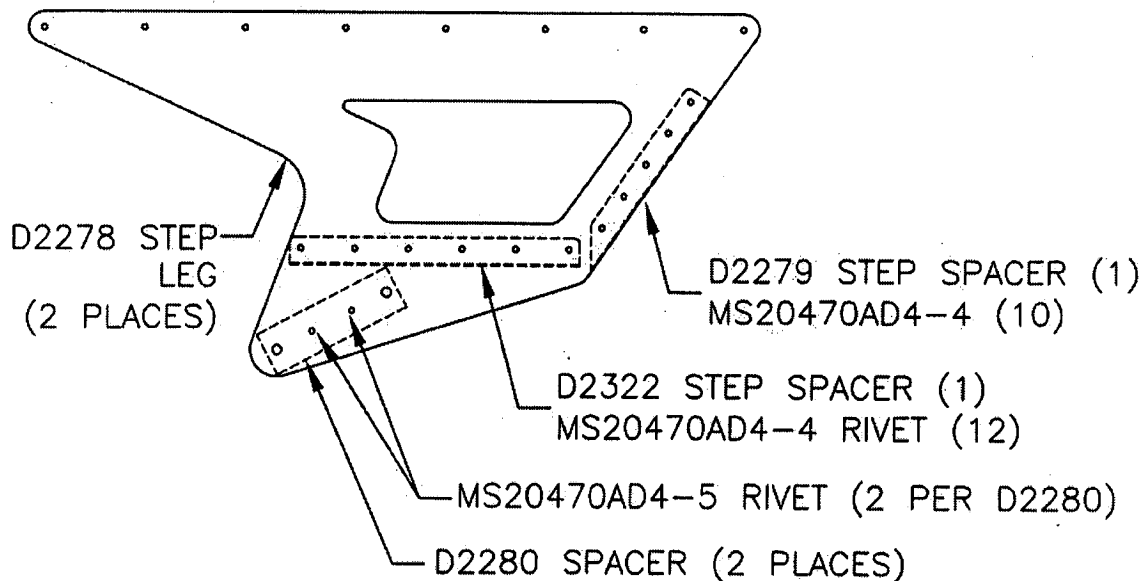
NOTE: Date & initial all entries

QA: N/C Closed: _____ Date: _____



DESIGN <i>CP</i>	DRAWN BY <i>CP</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>#</i>	APPROVED <i>#</i>	DRAWING NO. D2582	REV. A SHEET 1 OF 1
DATE 01.10.05		TITLE STEP LEG ASSEMBLY	SCALE 1:5
A	01.10.05	NEW ISSUE	

QTY	PART NUMBER	DESCRIPTION
2	D2278	STEP LEG
1	D2279	STEP SPACER
2	D2280	SPACER
1	D2322	STEP SPACER
22	MS20470AD4-4	RIVET
4	MS20470AD4-5	RIVET



D2582

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
01-10-16 SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 27756

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